

June 27

Dart Aerospace Ltd.

Date: Thursday, 6/7/2007 3:31:15 PM  
 User: Kim Johnston

## Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI UTILITY BASKET, LIGHTWEIGHT, SHORT  
 Job Number : 32862  
 Estimate Number : 12245  
 P.O. Number : N/A Part Number : D350721043  
 This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NO Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : N/A  
 Previous Run : 31900 Material : N/A  
 Due Date : 6/26/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : KS 07.06.08  
 Comment : Est A 05.02.09 New issue KJJ/LM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-043 CHG001

KS 07.08.11

2.0 32862A BASKET BASE ASSEMBLY



Comment: Sub-Component BASKET BASE ASSEMBLY

D3326-041 B 32862 A

ml 07/06/21

3.0 32862B BASKET LID ASSEMBLY



Comment: Sub-Component BASKET LID ASSEMBLY

D3327-041 B 32862 B

ml 07/06/21

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2022-101

Spacer

B30543

KS 07/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 6/7/2007 3:31:16 PM  
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## Process Sheet

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Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Assembly

B31105

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Assembly

B31106

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring

B28363

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

B31107

10.0

D27291

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Assembly Kit

Qty Part Number

Description Batch

1 D2729-1

Label

N/A

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper

B21139

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3320043

Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3320-043

Webbing

B32866

13.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

B31664

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

A103691

15.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

A102140

16.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

A16895

17.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

A104214

*CP 07/06/180*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt M103962

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer M103691

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer M103962

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer M103641

22.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer M104156

23.0

AN960JD9

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

24 AN960JD9

Washer M16499

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M103344

25.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

24 MS20600AD4W3

Rivet

M102929

26.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2

Rivet

M4747

27.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M103691

28.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M102552

*EP 07/06/1801*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

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Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5 Nut (or -5) 14102536

*EP 07/06/180*

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721

Attach Travelers:

*ml 07/06/27 x1*

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*ml 07/06/27 x1*

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

3 D2230-1

Lug

1530992 ✓

✓

34.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

1530993 ✓

✓

35.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total : 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

*EP 07/06/180* ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description:

4 D2856-4007.20" Abrasion Strip B32020 ✓

36.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3338-1

Lug

B23797 ✓

37.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D3350-041

Strut

B32590 ✓

38.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M103962 ✓

39.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M104118 ✓

40.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN4-14A

Bolt

M102473 ✓

*[Handwritten Signature]*  
6/14/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/26/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 6/7/2007 3:31:16 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET, LIGHTWEIGHT, SHORT

Job Number: 32862

Part Number: D350721043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

28 AN960JD416

Description Batch

Washer 17103691 ✓

42.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

16 MS21042L4

Description Batch

Nut (or -4) 17102552 ✓

43.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

44.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-043

Location:

PPP Rev:

45.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 6/7/2007 3:31:20 PM  
 User: Kim Johnston

## Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET LID ASSEMBLY  
 Job Number : 32862B  
 Estimate Number : 11332  
 P.O. Number : N/A Part Number : D3327041  
 This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : D3327 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : 31900B Material : N/A  
 Due Date : 6/26/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.06.08  
 Comment : Est A 05.02.09 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 15.2250 f(s)/Unit Total : 15.2250 f(s)  
 Material: 4130 Cond. N Square tube per MIL-T-6736,  
 1/2" x 0.035" wall  
 M4130N-TS0.500W.035)

M17679

07/06/12

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
 1-Cut tubes as per Dwg D3327

Qty	Part Number	Description	Batch
2	D3328-1	Hinge Plate	B 32846
2	D3349-1	Spacer Bushing	B 32588
1	D3352-1	Label Plate	B 28110
2	D3367-1	Mounting Bracket	B 32478

Batch  
 B 32846  
 B 32588  
 B 28110  
 B 32478

Identify parts appropriately

2-Remove all markings from material and deburr as required.  
 Check for foreign objects.

3-Drill and Weld as per Dwg D3327 & QSI 004  
 A/RN/ASteel Rod M108226

4-Deburr as required

07/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 32862B

Part Number: D3327041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-06-14 ①

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-14 ①

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M104144

4J 07-06-15 ①

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/21

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/06/21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/07/06/29

Job Completion



ml 07-06-28

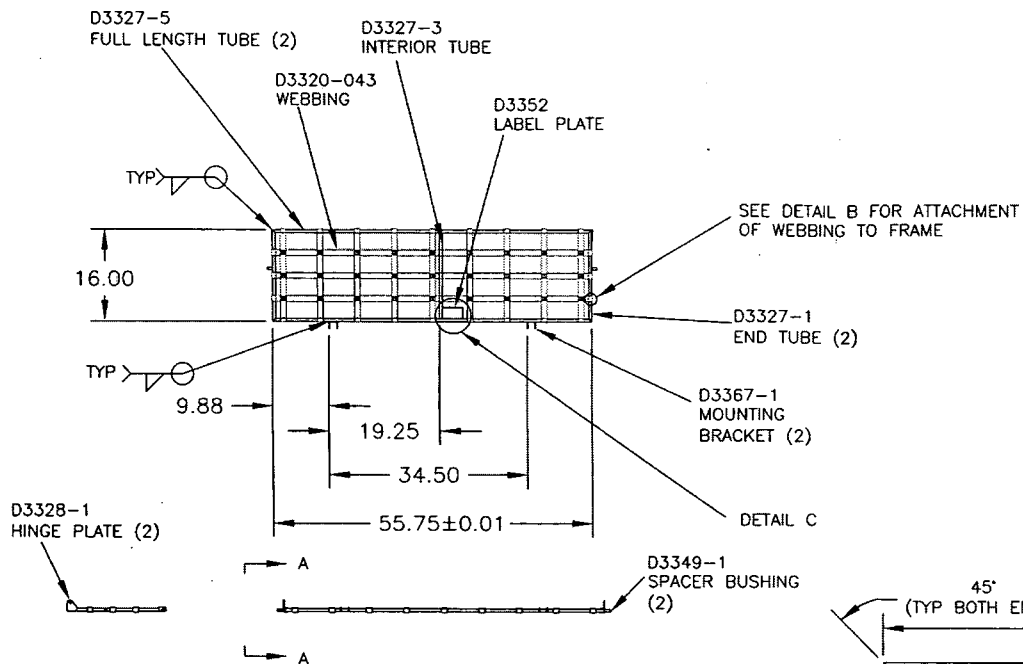
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

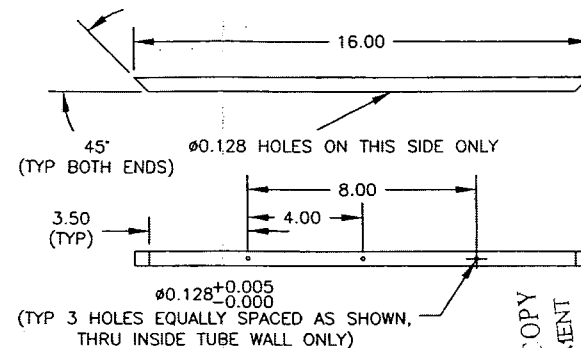


#### D3327-041 BASKET LID ASSEMBLY

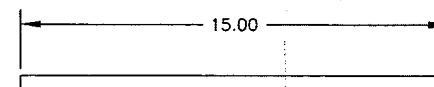
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-043)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### PARTS LIST FOR D3327-041 BASKET LID ASSEMBLY

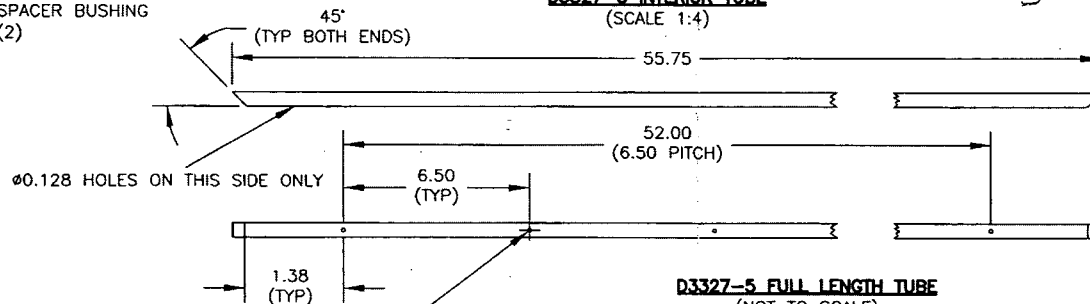
Part No.	Quantity	Description
D2729-1	1	PART ID LABEL
D3320-043	1	WEBBING
D3327-1	2	END TUBE
D3327-3	1	INTERIOR TUBE
D3327-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	24	RIVET
AN960JD9	24	WASHER



**D3327-1 END TUBE**  
(SCALE 1:4)



**D3327-3 INTERIOR TUBE**  
(SCALE 1:4)



**D3327-5 FULL LENGTH TUBE**  
(NOT TO SCALE)

#### D3327-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	CH	APPROVED
DATE	05.04.25	TITLE
		BASKET LID ASSEMBLY
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3327
		REV. B SHEET 1 OF 3
		SCALE 1:20

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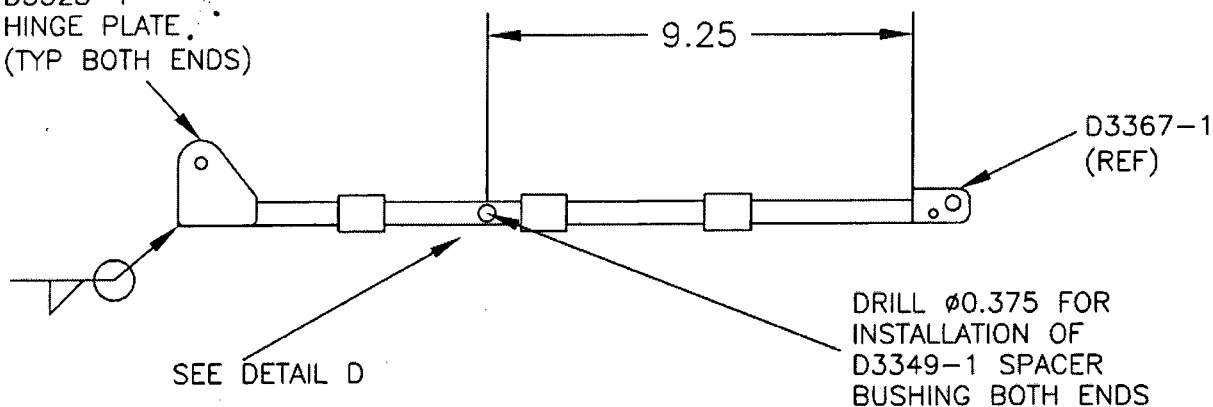
WORK ORDER  
3786-2-15

RELEASED  
05-11-2008

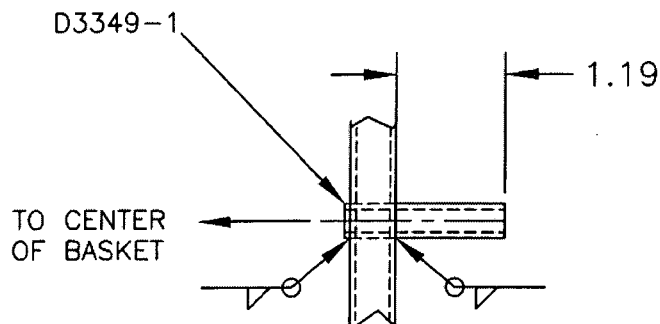


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3327	REV. 8 SHEET 2 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

D3328-1  
HINGE PLATE.  
(TYP BOTH ENDS)



VIEW A-A



DETAIL D  
(SCALE 1:2)

RELEASED  
05.04.28

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NO. 32862B

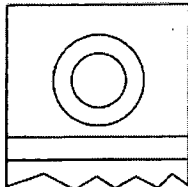
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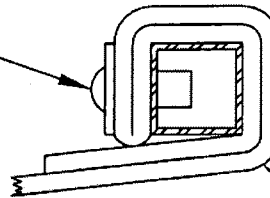


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DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



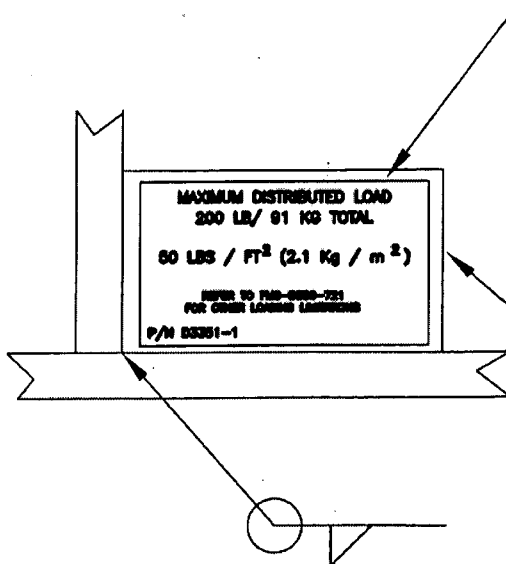
DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)



D3320-043 WEBBING

**RELEASED**  
05.04.28

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

D3352-1

IDENTIFY WITH DART P/N  
D350-721-043 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

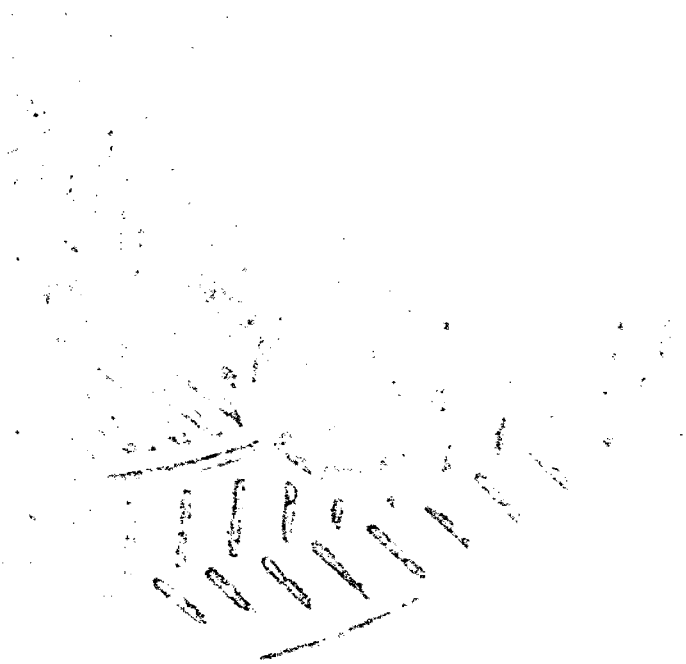
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OUTBOARD

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26

Date: Thursday, 6/7/2007 3:31:19 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY  
Job Number : 32862A  
Estimate Number : 11331  
P.O. Number : N/A Part Number : D3326041  
This Issue : 6/7/2007 S.O. No. : N/A Drawing Number : D3326 REV B  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
Previous Run : 31900A Material : N/A  
Written By : Due Date : 6/26/2007 Qty: 1 Um: Each  
Checked & Approved By : 07.06.08  
Comment : Est A 05.02.09 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 32.2875 f(s)/Unit Total : 32.2875 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736, 1/2" x 0.035" wall  
(M4130N-TS0.500W.035)  
Identify parts appropriately M17679 07/06/12

2.0 M569EX05018F 569 Expanded Metal



Comment: Qty.: 0.0061 sf(s)/Unit Total : 0.0061 sf(s)  
Pick:  
Qty Part Number Description Batch M101927  
28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel 07/06/12

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut tubes as per Dwg D3326

Qty	Part Number	Description	Batch
2	D3328-3	Hinge Plate	B 32847
4	D3348-1	Clevis	B 32587
2	D3349-3	Spacer Bushing	B 32589
2	D3367-1	Mounting Bracket	B 32478

Identify parts appropriately

07/06/13

2-Remove all markings from material and deburr as required check for foreign objects.

3-Drill and Weld as per Dwg D3324 & QSI 004  
A/RN/ASteel Rod M102226

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/04/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:31:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 32862A

Part Number: D3326041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Debur as required

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-06-14 (1)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-14 (1)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

MD 09-06-15 (1)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MD 07/06/21

8.0

PACKAGING 1

PACKAGING RESOURCE #1-



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MD 07/06/21

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MD 07/06/21

Job Completion



CA 07-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

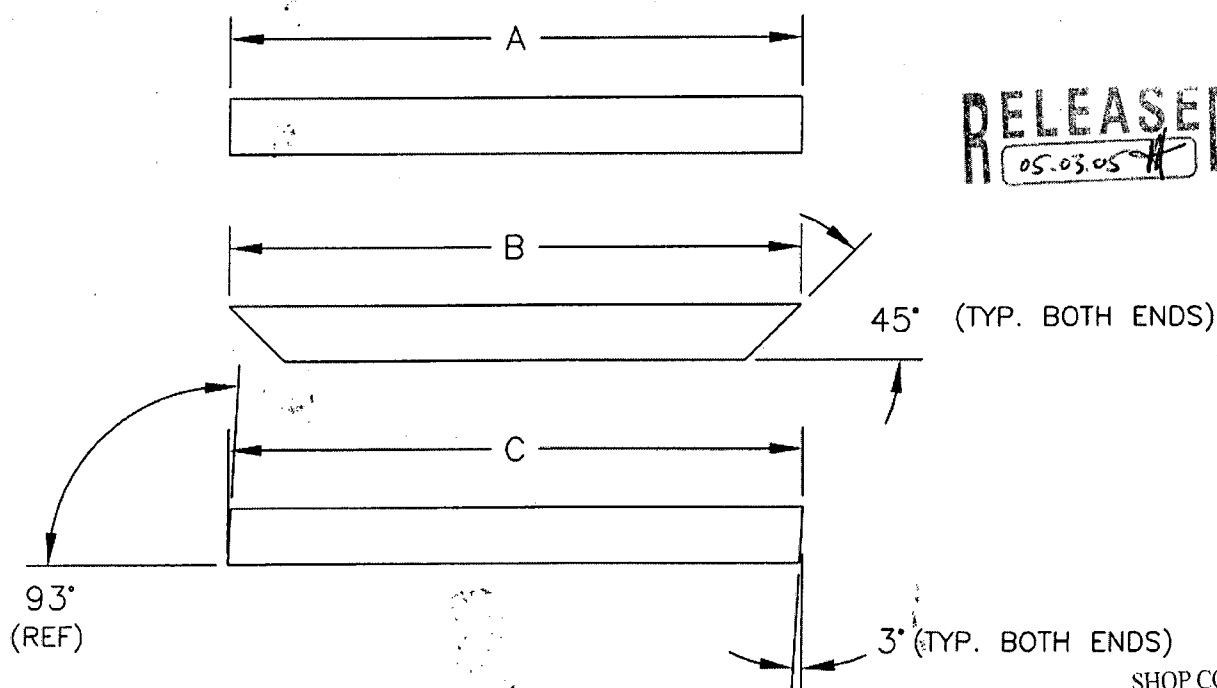
**NOTE:** Date & initial all entries



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3326	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.21	NEW ISSUE	
B	05.03.04	UPDATE TUBING AND MESH MAT'L SPEC	

PARTS LIST FOR D3326-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3326-1	1	14.00	N/A	N/A	BOTTOM TUBE
D3326-3	4	N/A	56.50	N/A	FULL LENGTH TUBE
D3326-5	2	N/A	16.00	N/A	TOP END TUBE
D3326-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3326-9	6	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



D3326-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL  
(REF. DART SPEC M4130-TS0.500W.035)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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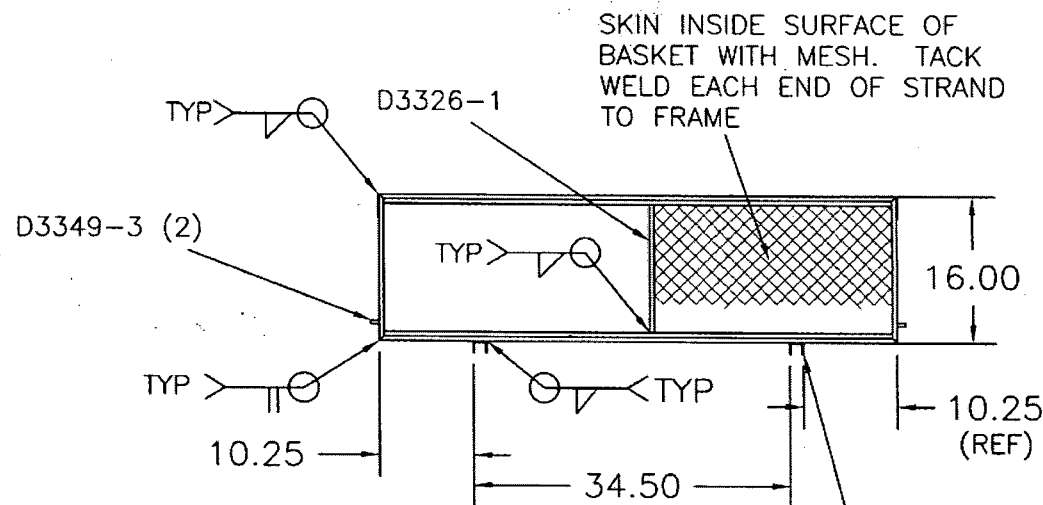
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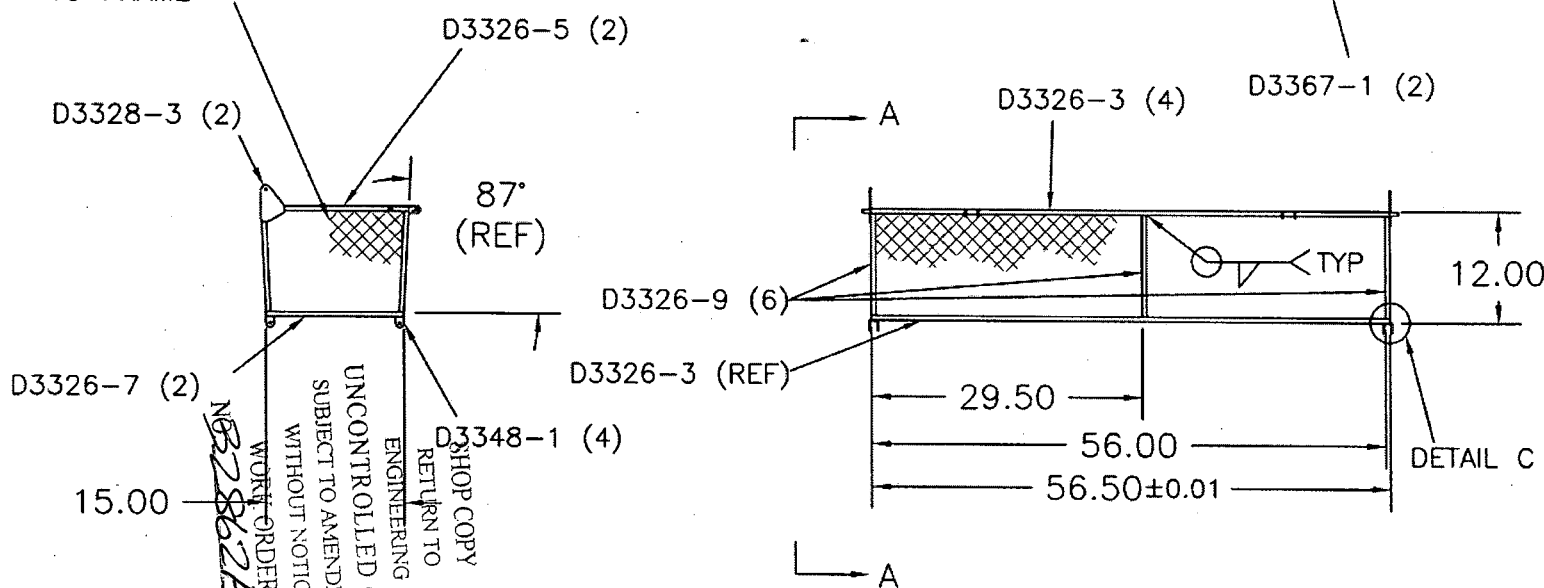
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DATE	DRAWING NO.	REV. B
05.03.04	D3326	SHEET 2 OF 3
	TITLE	SCALE
	BASKET BASE ASSEMBLY	1:25



SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



#### D3326-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18 GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0

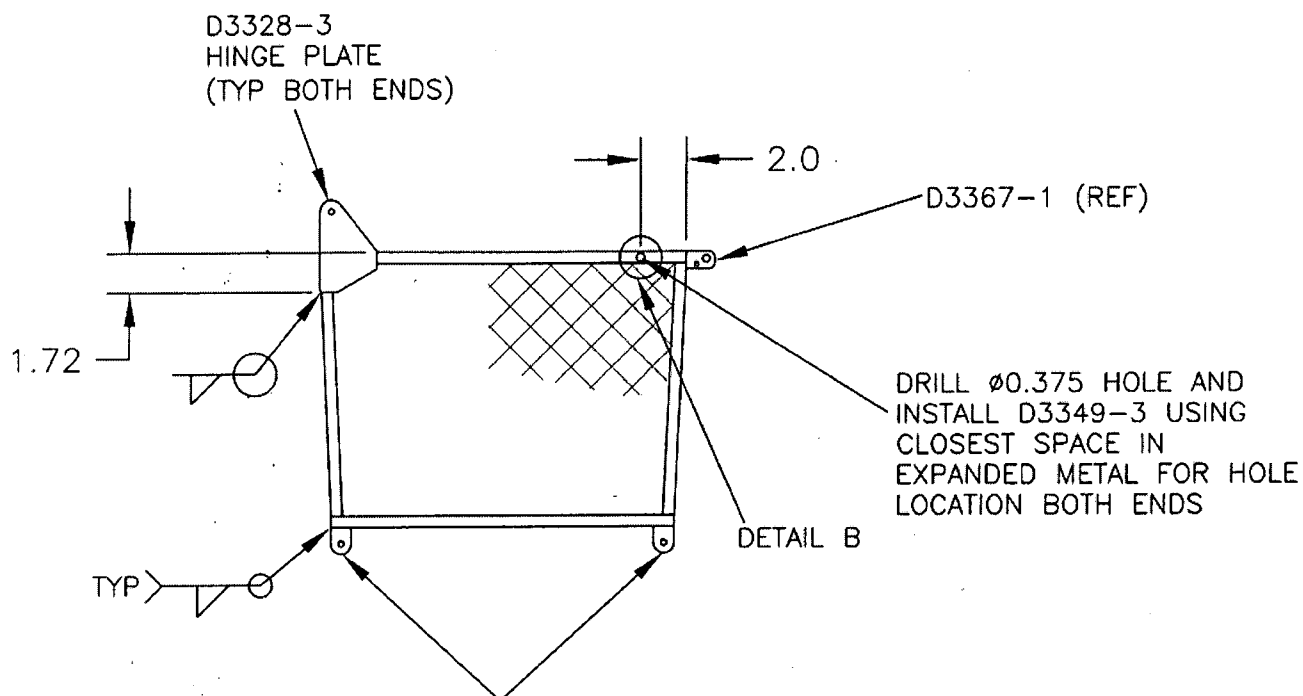
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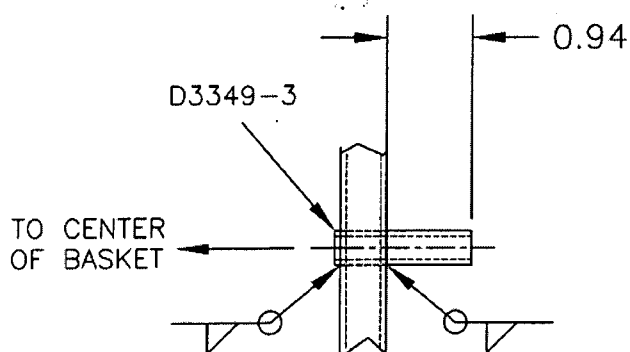
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DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



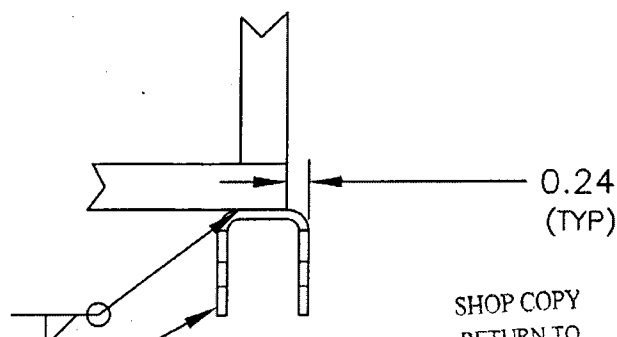
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D3348-1  
(2 PER END, 4 TOTAL)

VIEW A-A



DETAIL B  
(SCALE 1:2)



D3348-1  
(2 PER END, 4 TOTAL)

DETAIL C  
(SCALE 1:2)

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